

# Work Order ID 59969

Tuesday, June 22, 2010 10:00:02 AM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 6/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: *10-6-27*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

*8.10.07.29*

*HJ for BG 10/07/28*

110



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

*M112860*  
*M114242*

3-Grind End Plate flush

*Ph 10.07.21 10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC Quality Control	Memo	0.00				⑤	10	1007.21	
130 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00				④	10	1007.21	
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00				10	10	1007.21	

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Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				(10)	✓		
180 Large Fab	Large Fab  Memo	0.00  0.00				10	✓		
	1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> 1/4" 112860 6-Grind End Plate flush 7-Install last rivet as per Dwg.								

SAD  
10-07-21

10-07-23

**Dart Aerospace Ltd**

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 10.07.26

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/07/26

410  
RH

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ml

10

07

26

10

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 5

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220



Powdercoat

Powder Coating

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME: 1:30

0.00

OVEN TEMPERATURE: 320°

FINISH TIME: 2:00

10. 10-7-27

230



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M115028

0.00

Memo

810 4

240



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Cal 7/22 10

W/O:		WORK ORDER CHANGES						
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Page 6

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  Packaging Packaging	Pick Kit  Memo	0.00  0.00							
260  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00							
270  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPPD350-591-312 Location: _____	0.00  0.00							

10/7/29 (10)

410  
RH

510102129

few B

10/7/29 sl (12)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DCA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 7

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Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Setup Start

Stop

Run Start

Stop

10/07/30

10-7-30

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Page 1

Work Order ID: 59969

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 6/22/2010




Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

## Comments:

IPP Rev:A 04.03.22 New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC  
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1  End Plate		Manufactured	No			110	Each	3.0000	1	10			
<div> <div>Location</div> <div>WA 359596</div> <div>57926</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3272-1  Step		Manufactured	No			110	Each	10.0000	1	10			
<div> <div>Location</div> <div>WA 359971</div> <div>59952</div> </div> <div> <div>Loc Qty</div> <div>10</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3065-041  Step Leg Assembly Hi		Manufactured	No			180	Each	14.0000	1	10			
<div> <div>Location</div> <div>WA 359678</div> <div>58160</div> <div>58536</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>1</div> <div>13</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

10.07.21

10

10.07.19

10

10.07.22

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No 180 Each 77.0000 2 20



Spacer

Location	Loc Qty	Loc Code
WA	77	
58540	77	



10.07.22

D3067-1 Manufactured No 180 Each 3.0000 1 10



End Plate

Location	Loc Qty	Loc Code
WA	3	
57926	3	



10.07.22

D3219-1 Manufactured No 180 Each 113.0000 2 20



Plate

Location	Loc Qty	Loc Code
WA	113	
58550	17	
59597	96	



10.07.21

MS20600-AD4W4 Purchased No 180 Each 959.0000 16 160



Rivets

Location	Loc Qty	Loc Code
ST321	959	
113368	62	
114181	11	
114718	2	
114935	884	



10.07.23

160

Tuesday, June 22, 2010 10:00:06 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

AN3-35A

Purchased

No

250

Each

17.0000

20



Bolt

## Location

## Loc Qty

## Loc Code

ST353

17

114784

17

AN4-13A

Purchased

No

250

Each

478.0000

80



Bolt

## Location

## Loc Qty

## Loc Code

ST357

478

114941

478

AN5-36A

Purchased

No

250

Each

269.0000

20



Bolt

## Location

## Loc Qty

## Loc Code

ST341

269

114292

19

114784

50

114941

200

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

40



Washer

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

6.0000

160



Washer

## Location

## Loc Qty

## Loc Code

ST357

6

107939

6

Tuesday, June 22, 2010 10:00:06 AM

Shop Packet Print

Page 3

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Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

AN9601D516 NAS1149D0563J Purchased No

250 Each

0.0000

4 40



Washer

D2230-3

Manufactured No

250 Each

179.0000

4 40



Lug

## Location

## Loc Qty

## Loc Code

ST476

179

55452

2

59115

17

59418

160

D2618

Manufactured No

250 Each

25.0000

2 20



Bushing

## Location

## Loc Qty

## Loc Code

ST020

25

56892

1

57829

24

D2856-400

Manufactured No

250 f

182.7820

0.6

6



Abraison Strip

## Location

## Loc Qty

## Loc Code

ST403

182.782

56626

182.782

D3235-1

Manufactured No

250 Each

103.0000

2 20



Mounting Lug

## Location

## Loc Qty

## Loc Code

ST471

103

58717

43

59125

60

Tuesday, June 22, 2010 10:00:06 AM

Shop Packet Print

Page 4

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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 10.00

Required Qty: 10.00

D3278-041

Manufactured No

250

Each

60.0000

1

10



Support Assembly

Location

Loc Qty

Loc Code

ST471

60

59633

60

250

Each

3,085.000

2

20

MS21042L3

Purchased No



Nut

Location

Loc Qty

Loc Code

ST300

3085

114523

585

114718

500

114784

2000

250

Each

3,046.000

8

80

MS21042L4

Purchased No



Nut

Location

Loc Qty

Loc Code

ST300

3046

113422

68

114523

28

114718

950

114784

2000

250

Each

681.0000

2

20

MS21042L5

Purchased No



Nut

Location

Loc Qty

Loc Code

ST139

500

114813

500

ST300

181

114449

181

Tuesday, June 22, 2010 10:00:06 AM

Shop Packet Print

Page 5

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DESIGN <i>QD</i>	DRAWN BY <i>JB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.18 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET



**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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WORK ORDER  
NO. *39969*

*Pl 10-6-22*

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DOA: \_\_\_\_\_ Date: \_\_\_\_\_

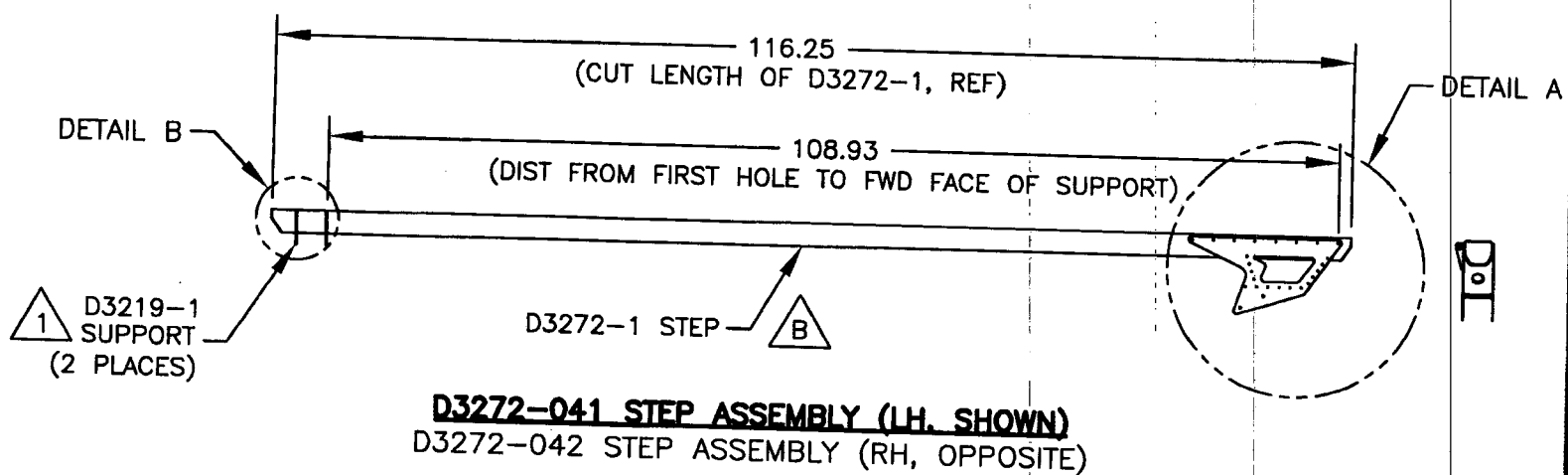
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

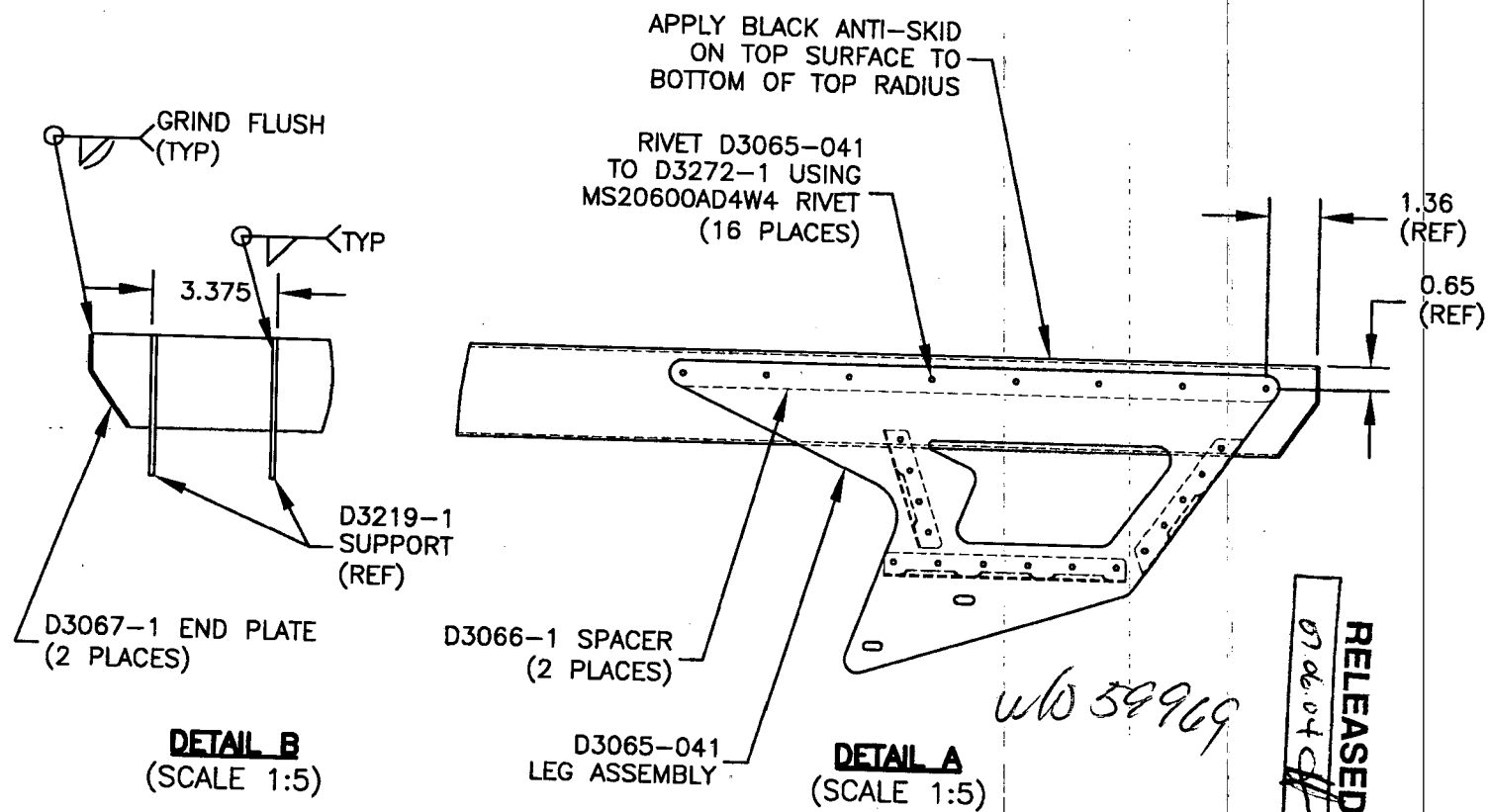
**NOTE:** Date & initial all entries

# DART

DESIGN	40	DRAWN BY	J.B.	DART AEROSPACE LTD
CHECKED	Le	APPROVED	J.B.	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

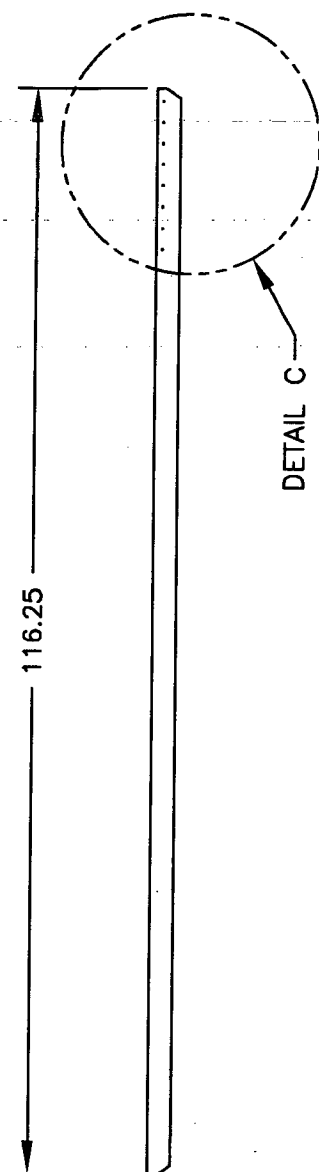
**NOTE:** Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

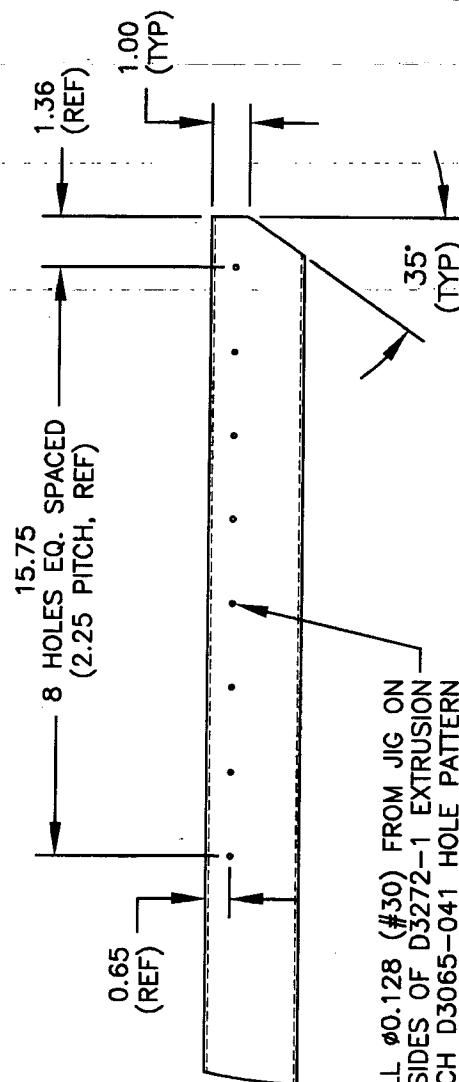
RELEASED

07.06.04 *[Signature]*



**B** D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



**DETAIL C**  
(SCALE 1:5)

*W/O 59969*

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD.

D350-591  
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: **G**  
Date: 08.10.06